

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012425**Date Inspected:** 03-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 7BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG035A-005. The welder is identified as #069683 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-B-U2-FCM-1.

Segment 6AW

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) on FL3 bottom flange hold back CJP weld at panel point 40.

This QA Inspector observed ABF personnel performing UT Longitudinal Diaphragm flange to floor beam web, east panel point 37.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on FL3 Bottom Panel stiffener hold back fillet welds at panel point 38-40.

Segment 6CW

This QA Inspector observed beveling of Deck Plate I-ribs by hand flame cut at panel point 47 field splice, counter weight side.

Lift 5 East

This QA Inspector observed grit blasting in progress of interior components.

Segment 6AE

This QA Inspector observed ZPMC personnel performing MT on FL3 web stiffener hold back welds at panel point 39.

Segment 6BW/6CW

This QA Inspector observed ABF personnel performing MT on Side Plate WT stiffener hold back fillet welds, cross beam side.

Segment 6CE

This QA Inspector observed beveling of Deck Plate I-ribs by hand flame cut at panel point 47 field splice, bike path side.

Segment 6BE

This QA Inspector observed grit blasting in progress on interior components.

Segment 7AW

This QA Inspector observed ABF personnel performing MT on approximately 1700mm on the Side Plate to Bottom Plate CJP weld west of panel point 48, counter weight side.

Segment 7BW/7CW

This QA Inspector observed ABF personnel performing MT at locations of removed fit up plates along Side Plate CJP segment splice, cross beam side.

ZPMC Quality Control (QC) Inspector is identified as Wang Li Wang. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
